

# Work Order ID 66318



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February 9, 2011 3:42:20 PM

Item ID: D206-628-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 2/17/11 Start Qty: 3.00



Cust Item ID:

Required Date: 3/03/11 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-02-10

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-023 CHG 003

8/11/09/114

HJ for BG 11-9-3

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/3/10 (32) D

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/11/09/114

43  
LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66318**

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Item ID: D206-628-023

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Required Date: 3/03/11 Req'd Qty: 3.00



Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00				11/3/11			(3)
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD206-628-023 Location: <u>91</u> PPP Rev: <u>4</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/3/15

MF 11-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 66318

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH



Start Date: 2/17/11

Required Date: 3/03/11

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:D As Per Ecn766 06-01-06 JLM  
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC  
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A		Purchased	No			120	Each	1,600.000	3	9			
BOLT													

Location	Loc Qty	Loc Code
ST350	1600	
115300	25	
116075	491	
116590	84	
116704	1000	

AN4C14A		Purchased	No			120	Each	57.0000	4	12			
Bolt													

Location	Loc Qty	Loc Code
ST358	57	
115835	7	
115936	50	

AN4C15A		Purchased	No			120	Each	93.0000	8	24			
Bolt													

Location	Loc Qty	Loc Code
ST358	93	
115936	93	

AN960C10	NAS1149C0363 R	Purchased	No			120	Each	0.0000	3	9			
WASHER													

M117010 11/3/10

M113110 11/3/10

M113289 11/3/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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February 9, 2011 3:42:19 PM

Work Order ID: 66318

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 2/17/11

Required Date: 3/03/11

Start Qty: 3.00

Required Qty: 3.00

AN960C416L

Purchased No

120

Each

19.0000

24 72



WASHER



M116900 11/3/10

D2731-7

Manufactured No

120

Each

68.0000

4 12



Mounting Lug



11/3/10

## Location

## Loc Qty

## Loc Code

ST346

19

112828

19

## Location

## Loc Qty

## Loc Code

ST420

2

65224

2

ST470

66

61653

1

62402

15

62929

50

D2732

Manufactured No

120

f

529.9793

2 6



Rubber Extrusion



11/3/10

## Location

## Loc Qty

## Loc Code

ST410

500

64283

500

ST412

29.979279

56516

29.979279

(D2732-030) Cut (8) at 3.00"

D2842-041

Manufactured No

120

Each

0.0000

13



Step Assembly, 206 Float



B66372

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 66318

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 2/17/11

Required Date: 3/03/11

Start Qty: 3.00

Required Qty: 3.00

D2844-1  
Arm

Manufactured No 120 Each 17.0000

11/3/10 SP B66561

Location Loc Qty Loc Code

ST265 17  
52030 1  
62954 16

D2844-3  
Arm

Manufactured No 120 Each 13.0000

11/3/10 SP

Location Loc Qty Loc Code

ST265 13  
61453 1  
62967 12

D3394-043  
Lug Assembly

Manufactured No 120 Each 87.0000

11/3/10 SP (3x)

Location Loc Qty Loc Code

ST420 3  
62589 3  
ST475 84  
62005 6  
62667 8  
62930 40  
62976 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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February 9, 2011 3:42:19 PM

Work Order ID: 66318

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 2/17/11

Required Date: 3/03/11

Start Qty: 3.00

Required Qty: 3.00

MS21043-4

Purchased

No

120

Each

1,029.000

12

36



Nut

## Location

## Loc Qty

## Loc Code

ST301

1029

114523

5

114784

2

115936

126

116188

596

116549

300

NAS1515H3

Purchased

No

120

Each

150.0000

3



Washer

## Location

## Loc Qty

## Loc Code

ST277

150

115935

50

116373

100

NAS1515H4L

Purchased

No

120

Each

106.0000

24

72



WASHER

## Location

## Loc Qty

## Loc Code

FG

40

103691

40

ST277

66

112492

11

114265

55

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5.2 D206-628-013/-014/-023/-024/-033/-033 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X		✓				D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	AN960C10	WASHER
24	24	24	24	24	24	AN960C416L	WASHER
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER



\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

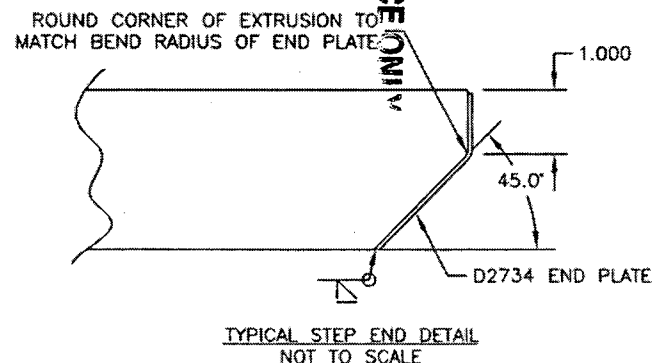
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Revision: F

Date: 08.02.07

DESIGN KE	DRAWN BY PH	DARI AEROSPACE USA, INC. PORT HADLOCK, WA		REV. B
CHECKED 	APPROVED 	DRAWING NO. D2842	SHEET 1 OF 1	
DATE 05.09.23		TITLE 206L/407 FLOAT STEP ASSEMBLY		SCALE NTS
A	98.10.13	NEW ISSUE		
B	05.09.23	RE-DESIGN, ADD D3459-1/-3		



QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN950C 10L	WASHER

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
05-11-14

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